



(19)

(11) Publication number: **611870**

Generated Document.

**PATENT ABSTRACTS OF JAPAN**(21) Application number: **60027899**(51) Intl. Cl.: **G05B 9/02 G05B 7/02 G05B 19/02**(22) Application date: **14.02.85**

(30) Priority:

(43) Date of application  
publication: **20.08.86**(84) Designated contracting  
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**(54) HOT/COLD START  
AUTOMATIC SWITCHING  
METHOD OF  
PROGRAMMABLE  
CONTROLLER**

(57) Abstract:

**PURPOSE:** To start the control from before a stop stage by cold-starting a program controller if a sequence program is abnormal when it is judged after restoration from power failure that the program controller should be hot-started.

**CONSTITUTION:** After restoration from power failure, it is judged whether the program controller (PC) should be hot-started or cold-started, and a data RAM4 for sequence program is checked when the PC should be hot-started. If the check result is normal, the hot start processing is performed; but if the check result is abnormal, the cold start processing is performed. The PC judges whether the hot start processing is performed or the cold

start processing is performed by the PC itself and switches the processing automatically to control a process after restoration of power.

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